Qty:

10 Um:

Each

: BASKET HINGE

: D22323

: N/A

: C

: D2232 REV C

: 17/04/2009

Date: User: Tuesday, 07/04/2009 10:17:56 AM

Julie Dawson

Process Sheet

Drawing Name

Part Number

Material

Due Date

Drawing Number

Project Number

Drawing Revision

Customer Job Number : CU-DAR001 Dart Helicopters Services

: 46949

Estimate Number

: 10588

P.O. Number

This Issue

: 07/04/2009 Prsht Rev.

: NC

: //

Type

S.O. No. :

: SMALL /MED FAB

: 46822

Written By

Checked & Approved By

Comment

First Issue

Previous Run

: Est. 01.06.07 В

Now laser cut 'EC Est Rev:C Now on Waterjet 06-10-26 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M304S11GA

304/316 0.125 Sheet

Comment: Qty.:

0.0729 sf(s)/Unit

Total:

0.7287 sf(s)

304/316 .125 Sheet

Batch: ((O Y

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2232

Dwg Rev:___ Prog Rev:_

B9-4-16



QC2

INSPECT PARTS AS THEY COME OFF MACHINE



2-Deburr if necessary

HR9-4-16

PARTS AS THEY COME OFF MACHINE Comment: INSPECT

4.0

3.0

QC8

SECOND CHECK



Comment: SECOND CHECK



5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr



Dart Aerosp	oace	Ltd
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W/O:	•		W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHA	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		•								
		·								
Part No	:	PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	A:	Date:		
			Disposition: Q							
NCR:		V	WORK ORD	ER NON-CONFORMA	NCE (NCI	R)				
DATE	STEP	Description of NC	Description of NC Corrective Acti		Ver			erification Approval Appr		
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign of Date		on C	Chief Eng	QC Inspector	
			·							
								·		
								,		

NOTE: Date & initial all entries

Date:

Tuesday, 07/04/2009 10:17:56 AM

User:

Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET HINGE

Job Number: 46949

Part Number: D22323

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

7.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock
Location:

QC21

FINAL INSPECTION/W/O RELEASE



TION/W/O RELEASE Comment: FINAL I

Job Completion



U 91.04.20

Dart Aerospace Ltd

W/O:			V	VORK ORDER	CHANGES						
DATE	STEP	PRO	OCEDURE CI	HANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
				1							
Part No						NCR: Yes No DQ			DQA: Date:		
	Res	solution:	Disposi	Disposition:			_ QA: N/C Closed:				
NCR:			WORK OR	DER NON-CON	FORMANC	E (NCR)				
DATE	STEP	Description of NC	1	Corrective Action Section B		- Varities		ation	Approval	Approval	
		Section A	Initial Chief Eng	Action Des	ng	Sign & Date	Sectio	n C	Chief Eng	QC Inspector	
								•			
											

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 1	76949
Description: Basket Hinge	Part Number:	D2232-3
Inspection Dwg: D2232 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	х	First Arti	cle	Prot	otype	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	+/-0.010	.500	~			
0.750	+/-0.010	751	V		,	
2.500	+/-0.010	2,506	<u> </u>			
1.000	+/-0.010	1.003	አ			
0.750	+/-0.010	751	<u>s</u>			
2.250	+/-0.010	2.750	<u>`</u>			
0.500	+/-0.010	1501	4			
Ø0.257	+0.006/-0.001	259	\sim			
			:			

			$\overline{}$			
Measured by:	IR.	Audited by:	8,	()	Prototype Approval:	N/A
Date:	9-4-16	Date:	3	07/04/1	Date:	N/A

Rev	Date	Change	Revised by Approved
Α	06.11.08	New Issue	KJ/JLM of B

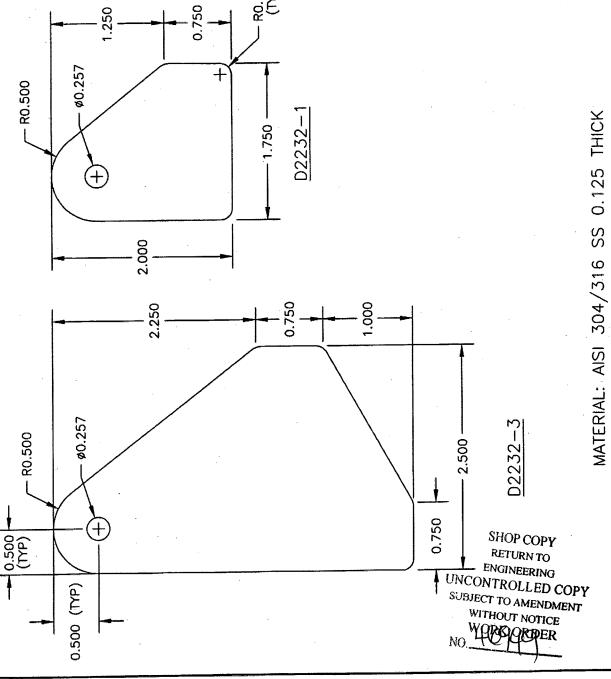




			·	
DESIG)	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CAN	
CHEC	(ED, /	APPROVED	DRAWING NO.	REV. C
1		IA	D2232	SHEET 1 OF 2
DATE		- /	TITLE	SCALE
98.0	4.28		BASKET HINGE	1:1
Α		94.05.12	NEW ISSUE	
В		96.01.02	ADDED -5 AND -7	
		08 04 28	0 125 THICK WAS 0 063	

RELEASED

0.125 THICK WAS 0.063



R0.125 (TYP)





DESIGN	DRAWN BY	DART AEROS	
1 4	1 1/2	HAWKESBURY, OF	ITARIO, CANADA
CHECKED /	APPROVED	DRAWING NO.	REV. C
NOX	IA	D2232	SHEET 2 OF 2
DATE	11)	TITLE	SCALE
98.04.28		BASKET HINGE	1:1

